

Work Order ID 79833

February-03-12 3:31:26 PM

ASAP

79833

Page 1

Item ID: D3537-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Wearpad

Stop *NS2*

Start Date: 03/02/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 10/02/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 12/02/06 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3537	Rev C

100 0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr if necessary

381.063

B12-2-9

(50)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-9

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Sizelator

water

(48)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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February-03-12 3:31:26 PM

79833

Page 4

Item ID: D3537-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearpad

Stop

NS2

Start Date: 03/02/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 10/02/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: FPI

0.00

190

Packaging

Memo

0.00

Packaging

502M/2P12/03/09

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLJ 12/03/0912-03-9

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NOTE: Date & initial all entries

Picklist Print

February-03-12 3:31:30 PM

Page 1
1

Work Order ID: 79833

79833

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 03/02/2012

Required Date: 10/02/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	28.4700	0.106	5.578947			

M304S16GA

304/316 Sheet .063

**

1B12-2-9

Location

Loc Qty

Loc Code

MAT020

28.47

120243

28.47

120243



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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

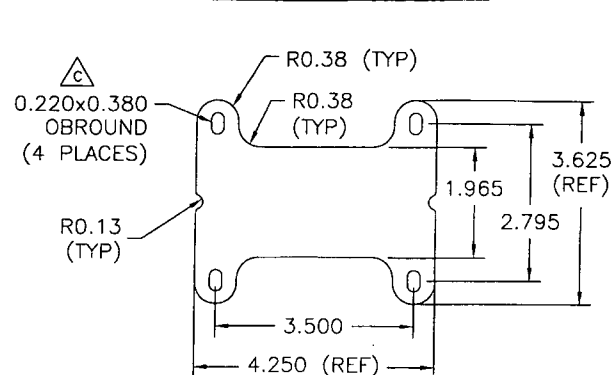
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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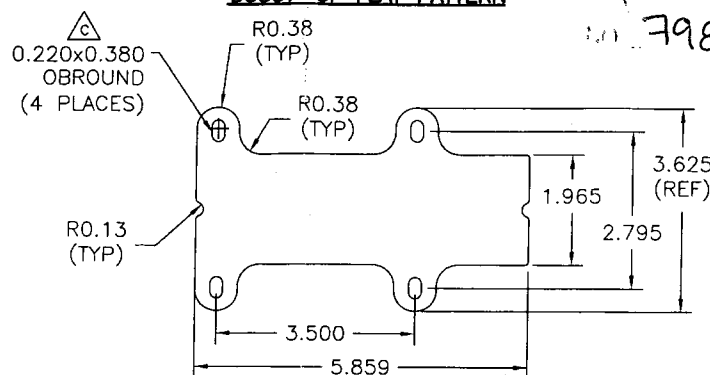
NOTE: Date & initial all entries

SECRET
UNCLASSIFIED

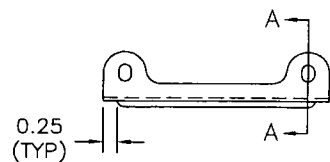
D3537-1F FLAT PATTERN



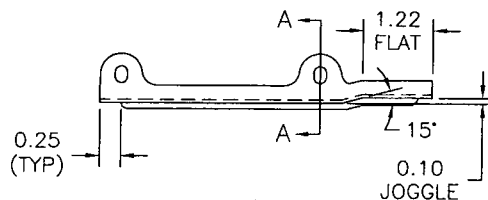
D3537-3F FLAT PATTERN



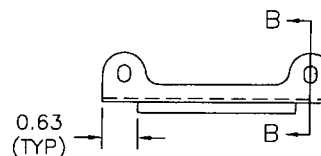
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



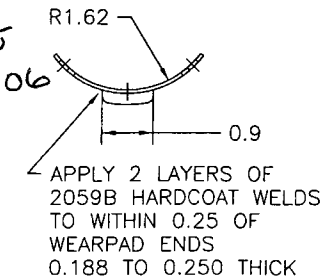
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



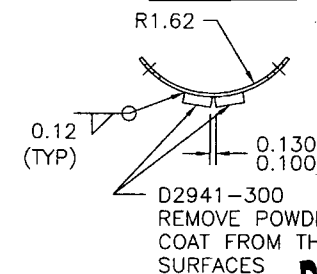
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



SECTION A-A



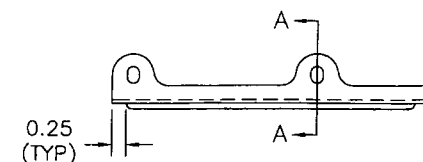
SECTION B-B



UNDER REVIEW
OK 9/11/15

RELEASED
07.05.08 AH
per ECU 962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART AEROSPACE USA, INC.
PORT HADLOCK, MA

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